

Date: Wednesday, 11/21/2007 12:50:29 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	35933			
Estimate Number	10533			
P.O. Number	N/A		Part Number	D2573
This Issue	11/21/2007	S.O. No. N/A	Drawing Number	D2573 REV E
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type	Drawing Revision	E
Previous Run	35917		Material	N/A
Written By			Due Date	12/23/2007
Checked & Approved By			Qty:	12
Comment	Est: 1	As Per RevE 06-01-27 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: B31389	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. 35933 Double check by: DSR	
	1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:50:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 35933

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA 08/01/04

11

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

08/01/07

7.0 POWDER COATING POWDER COATING



M 106379

11

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL 08-01-07

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-1

08/01/07

11X

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 433

AS 08/01/07 11

11

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/01/08

Job Completion



in 2008/1/18

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	35933
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	✓ DT8682	.440	.440	.440	.440		
B	1.745	1.755		1.747	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.002	8.002		
F	0.490	0.510	✓	.500	.502	.501	.502		
G	0.257	0.262	✓ DT8683	.258	.258	.258	.258		
H	0.375	0.380	✓ DT8684	.375	.375	.375	.375		
I	0.490	0.510		.502	.502	.504	.504		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.578	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.124	.124	.124	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.249	.250		
S	0.115	0.135		.115	.126	.126	.121		
T	0.178	0.198		.184	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.233	3.233		
V	0.230	0.250		.230	.240	.242	.238		
W	0.115	0.135		.105	.134	.125	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.750	.750	.760	.764		
Z	0.352	0.372		.370	.370	.370	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.500	1.520		1.510	1.510	1.510	1.500		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.265	.265	.265	.265		
AH	0.240	0.260		.260	.240	.252	.247		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	0.033	0.033	0.033		

Accept/Reject

Measured by: J-F / JML
 Date: 07/12/20 07/12/24

Audited by: SJ
 Date: 08/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<u>JML</u>

DART AEROSPACE LTD				Work Order:	35933
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	1/4	7/8	15/16		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755	G	1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.002		
F	0.490	0.510	H	0.501	0.502	0.501	0.502		
G	0.257	0.262	DT8683	.258	0.259	0.259	0.258		
H	0.375	0.380	DT8684	.375	0.376	0.376	0.376		
I	0.490	0.510	I	.500	0.502	0.501	0.502		
J	1.174	1.184		1.180	1.178	1.178	1.178		
K	0.558	0.578		0.568	0.567	0.568	0.570		
L	1.174	1.184		1.180	1.178	1.178	1.178		
M	1.365	1.375		1.370	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	4.119	4.129		4.124	4.121	4.122	4.123		
P	0.115	0.135		.124	0.126	0.125	0.126		
Q	0.115	0.135		.135	0.135	0.135	0.135		
R	0.240	0.260		.250	0.249	0.249	0.250		
S	0.115	0.135		.125	0.121	0.121	0.120		
T	0.178	0.198		.188	0.188	0.188	0.188		
U	3.210	3.250		3.233	3.230	3.230	3.230		
V	0.230	0.250		.250	0.239	0.237	0.237		
W	0.115	0.135		.125	0.123	0.123	0.120		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.761	0.760	0.760	0.761		
Z	0.352	0.372		0.364	0.364	0.364	0.363		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.631	0.631		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		.250	0.248	0.245	0.245		
AE	1.500	1.520		1.510	1.510	1.513	1.515		
AF	0.115	0.135		.125	0.135	0.125	0.126		
AG	0.240	0.280		.265	0.265	0.260	0.260		
AH	0.240	0.260		.250	0.248	0.247	0.248		
AI	2.000	2.020		2.000	2.002	2.002	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	85	Audited by:	SD
Date:	02/12/21 / 02/12/27	Date:	03/01/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SD

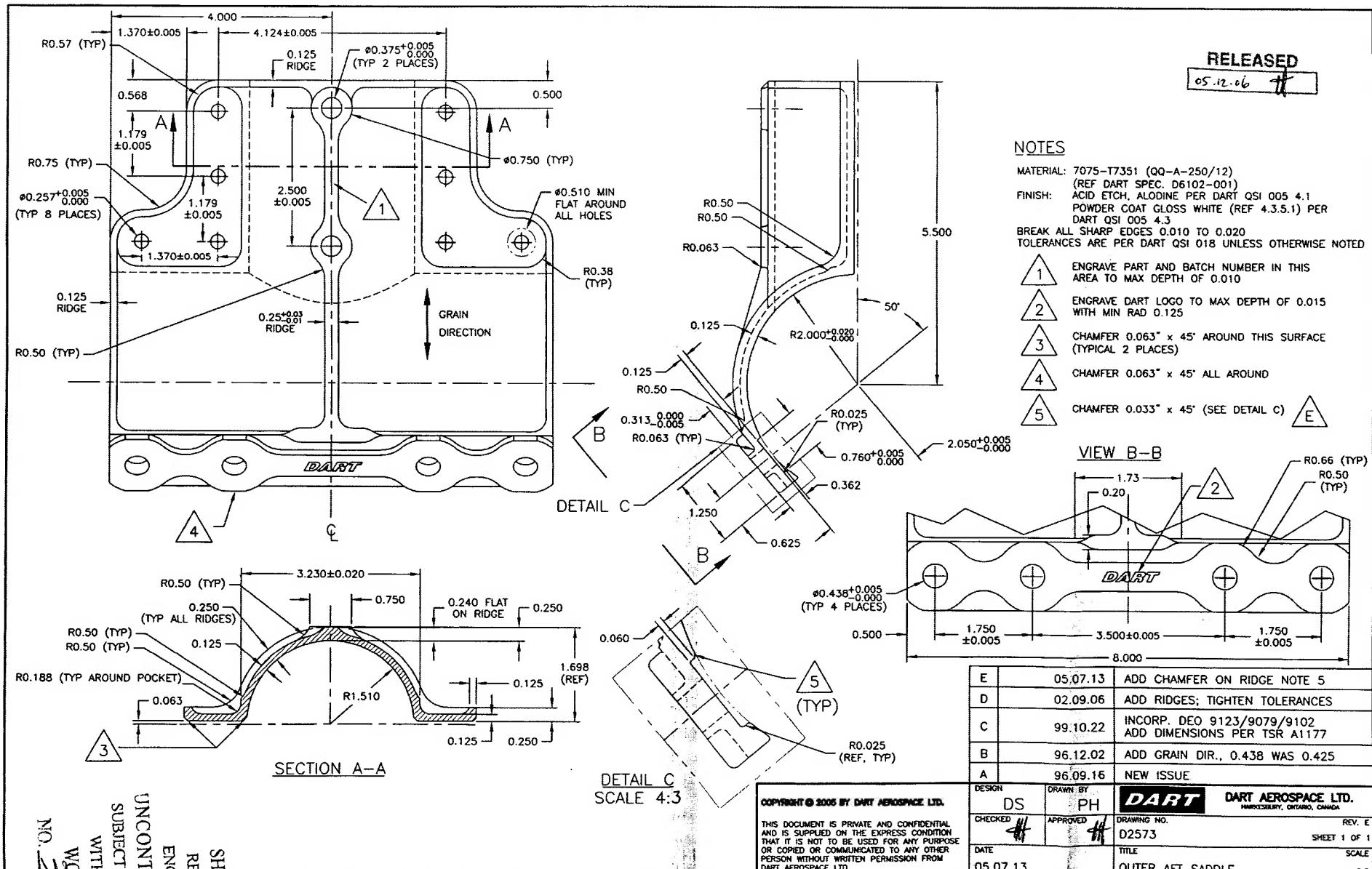
DART AEROSPACE LTD				Work Order:	35933
Description: Saddle, Aft Outboard				Part Number:	D2573
Inspection Dwg: D2573 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				17	210	311	412		
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.250	1.250	1.250		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510	6	0.500	0.502	0.503	0.504		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.376	0.376	0.376	0.376		
I	0.490	0.510		0.502	0.502	0.502	0.503		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.569	0.569	0.569	0.569		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.365	1.375		1.369	1.369	1.369	1.369		
N	2.495	2.505		2.499	2.499	2.506	2.506		
O	4.119	4.129		4.122	4.122	4.122	4.122		
P	0.115	0.135		0.126	0.126	0.126	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.249	0.249		
S	0.115	0.135		0.120	0.119	0.120	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.236	3.230		
V	0.230	0.250		0.239	0.238	0.237	0.237		
W	0.115	0.135		0.120	0.119	0.121	0.121		
X	0.308	0.313		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.762	0.760		
Z	0.352	0.372		0.362	0.364	0.362	0.363		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.632	0.632	0.633		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.245	0.247	0.247		
AE	1.500	1.520		1.512	1.512	1.512	1.512		
AF	0.115	0.135		0.126	0.126	0.126	0.126		
AG	0.240	0.280		0.260	0.260	0.260	0.266		
AH	0.240	0.260		0.247	0.247	0.247	0.247		
AI	2.000	2.020		2.002	2.002	2.002	2.003		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>ML</i>	Audited by:	<i>SD</i>
Date:	07/12/27	Date:	08/01/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>ML</i> <i>SD</i>	



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